

# Work Order ID 80181

\*80181\*

Page 1

February-13-12 10:41:53 AM

Item ID: D350-636-014

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Skidtube RH

Start Date: 13/02/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 12/02/13 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	F								
D3492	C								

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-014 CHG 006

13 8/12/12  
for M.L.J 12-4-20

80181

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80181****\*80181\***

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February-13-12 10:41:53 AM

Item ID: D350-636-014

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 13/02/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

**\*110\***

Skidtubes

0.00

Skidtubes

Skidtubes

**Memo**

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-4 details). Drill using drill Jig DT8150 &amp; DT8864A for first side only DT8864B for second side (detail B)

7- Clecko DT8864B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

B 12/24/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID 80181

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February-13-12 10:41:53 AM

Item ID: D350-636-014

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 13/02/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod batch: MA20164 JE 12/04/10

12-Grind welds flush as per Dwg D2750

120

QC10- Inspect visual per QSI004- ground welds

0.00

\*120\*

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

\*130\*

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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February-13-12 10:41:53 AM

Item ID: D350-636-014

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\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 13/02/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

Chemical Conversion Coat per QS1005 4.1

0.00

\*140\*

HandFinish

Memo

0.00

Hand Finishing

1 6 CF 12-4-10

150

QC3- Inspect Part Finish

0.00

\*150\*

QC


Memo

0.00

Quality Control

Qc7

① SAD 12-04-14

W/O: 80180		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-04-11	150	change Qc 3 to Qc 7	SAD 				

Part No: D350-636-014 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Skidtube RH

Start Date: 13/02/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00

**\*160\***

Skidtubes

0.00

Skidtubes

Memo

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015.

A/R Sikaflex-291

batch: 120413

exp. date: 12-06-13

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 11)

A/R Aluminum Rod

batch: m120854

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

JF 12-24-11

BE 12/4/12 } CF 12-4-16

S/CC 12/04/16

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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February-13-12 10:41:53 AM

Item ID: D350-636-014

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 13/02/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

MG 12-4-17 BR.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 80181

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February-13-12 10:41:53 AM

Item ID: D350-636-014

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 13/02/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

\*200\*

Powdercoat

Powder Coating

Memo

START TIME: 9:00

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:30

0.00

210

QC3- Inspect Part Finish

0.00

\*210\*

QC

Quality Control

Memo

✓ Inspect for foreign object per QSI 024

0.00

IX ✓ 12/04/18  
IX ✓ 12/04/18

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

**Work Order ID 80181****\*80181\***

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February-13-12 10:41:53 AM

Item ID: D350-636-014

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 13/02/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

0.00

**\*230\***

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per dwg D2750

2-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M110348

3-Assemble tube hardware as per dwg D2750

sika flex batch: 12/221

4-Inspect For Foreign Objects

13/015-Spray inside of tube with "LPS-3" batch: N/A

6-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: 121221EXP DATE: 13/01

7-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M110348

8-Coat all exposed fasteners with "LPS Procyon"

batch: 114596

1	<del>6</del>	<u>SP</u>	<u>12/04/19</u>
RH			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 80181****\*80181\***

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February-13-12 10:41:53 AM

Item ID: D350-636-014

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 13/02/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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240

QC5- Inspect part completeness to step on W/O

0.00

**\*240\***

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

**\*260\***

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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February-13-12 10:41:53 AM

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 13/02/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
<b>*270*</b>	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-014								
280		0.00							
<b>*280*</b>	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

1204-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

February-13-12 10:41:56 AM

Page 1

Work Order ID: 80181

\*80181\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:H02.09.25Rearranged procedure stepsKJ  
 IPP Rev:I05.12.08Rearranged procedure stepsEC  
 IPP Rev:J06.03.30Per rev. D EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-09-23 revF as per dwg DD verified by:ec IPP Rev:N  
 10.06.22 revise seq110 DD verf:EC IPP Rev:O 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-3-BENT

Manufactured

No

110

Each

12.0000

1

1

\*D2600-3-BENT\*

Extrusion Bent

\*\*

① 12/04/09

### Location

LG

82347

### Loc Qty

12

66875

7

73253

1

75021

1

75022

1

75023

1

77623

1

### Loc Code

D2739

Manufactured

No

160

Each

3.0000

1

1

\*D2739\*

350 I Beam

\*\*

① 12-04-11

### Location

LG

### Loc Qty

3

72155

1

78898

2

### Loc Code

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 80181

**\*80181\***

Parent Item: D350-636-014

**\*D350-636-014\***

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160

Each

172.0000

8

8

**\*D2743\***

Crossbolt Spacer

**\*\***LocationLoc QtyLoc Code

LG001

172

67766

4

68251

3

73403

64

74445

2

78603

99

*BE 12/04/12*  
*B 81965 x 8*

D2744

Manufactured No

160

Each

20.0000

1

1

**\*D2744\***

Cap

**\*\***LocationLoc QtyLoc Code

LG002

20

62715

1

70881

12

71861

7

*BE 12/04/10*  
*B 78900 x 1*

D3490-1

Manufactured No

160

Each

57.0000

4

4

**\*D3490-1\***

Cross Bolt Spacer

**\*\***LocationLoc QtyLoc Code

LG001

57

62450

2

74875

4

77042

8

78793

43

*BE 12/04/12*  
*B 81976 x 4*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

February-13-12 10:41:56 AM

Work Order ID: 80181

**\*80181\***

Parent Item: D350-636-014

**\*D350-636-014\***

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-5 Manufactured No

160 Each 20.0000 4 4

**\*D3490-5\***

Cross Bolt Spacer

\*\*

*BE 12/04/12*

Location

Loc Qty

Loc Code

LG001

20

59230

20

4

ALS4-1032-225 Purchased No

230 Each 1,408.000 38 38

**\*AI S4-1032-225\***

Insert

\*\*

*38 2P 02/04/19*

Location

Loc Qty

Loc Code

ST281

1031

108696

146

110768

62

118386

55

118966

68

120671

700

ST282

377

120410

200

120451

177

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 4

February-13-12 10:41:57 AM

Work Order ID: 80181

\*80181\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,058.000

34

34

\*AN3C5A\*

Bolt

\*\*

34

AP

12/04/19

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1051

116419

28

117343

13

117764

7

117872

2

119127

32

119749

27

120423 ✓

942

AN3C6A

Purchased

No

230

Each

332.0000

4

4

\*AN3C6A\*

BOLT

\*\*

4

AP

12/04/19

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

331

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423 ✓

242

February-13-12 10:41:57 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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February-13-12 10:41:57 AM

Work Order ID: 80181

\*80181\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

98.0000

4

4

\*AN6C44A\*

BOLT

\*\*

4

DP

12/04/19

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

96

120095

16

120143 ✓

25

120465

27

120641

28

AN8C35A

Purchased

No

230

Each

66.0000

1

1

\*AN8C35A\*

BOLT

\*\*

1

DP

12/04/19

Location

Loc Qty

Loc Code

FP002

65

115960

1

117834

10

118286 ✓

54

ST346

1

114442

0

115188

0

115960

1

AN960C10L

\*

NAS1149C0332

✓

Purchased

No

230

Each

0.0000

38

38

\*AN960C10I \*

washer

\*\*

38

DP

12/04/19

121255

February-13-12 10:41:57 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 6

Work Order ID: 80181

\*80181\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2745 Manufactured No

230 Each

48.0000 8 8

\*D2745\*

Bushing

\*\*

8

(SP)

12/04/19

Location

Loc Qty

Loc Code

FP001

48

69529

1

76142

1

78597

46

D3488-042 Manufactured No

230 Each

20.0000 1 1

\*D3488-042\*

Blade Fitting Assembly, RH

\*\*

1

(SP)

12/04/19

Location

Loc Qty

Loc Code

FP002

20

62003

1

71883

1

75068

9

77015

9

D3492-1 Manufactured No

230 Each

138.0000 8 8

\*D3492-1\*

Plug

\*\*

8

(SP)

12/04/19

Location

Loc Qty

Loc Code

FP002

138

69531

8

74444

2

76235

28

77037

100

D3492-5 Manufactured No

230 Each

32.0000 8 8

\*D3492-5\*

Plug

\*\*

8

(SP)

12/04/19

Location

Loc Qty

Loc Code

FP002

32

77044

32

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

February-13-12 10:41:57 AM

Work Order ID: 80181

\*80181\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

10.0000

1

1

\*D3535-25\*

Wearshoe

\*\*

1 (2P) 12/04/12

Location

80331 ✓

Loc Qty

Loc Code

FP001

1

62233

1

FP002

9

77617

9

D3536-25

Manufactured No

230

Each

18.0000

1

1

\*D3536-25\*

Gasket

\*\*

1 (2P) 12/04/12

Location

81342 ✓

Loc Qty

Loc Code

FP002

18

78902

18

D3537-1

Manufactured No

230

Each

19.0000

3

3

\*D3537-1\*

Wearpad

\*\*

3 (2P) 12/04/12

Location

73716 ✓

Loc Qty

Loc Code

FP002

19

69817

5

78591

14

D3631-1

Manufactured No

230

Each

223.0000

8

8

\*D3631-1\*

Washer

\*\*

8 (2P) 12/04/12

Location

68062 ✓  
75548 ✓

Loc Qty

Loc Code

ST072

223

2

221

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 80181

\*80181\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

230 Each

936.0000 8 8

\*D3672-1\*

Phenolic Washer

\*\*

Location	Loc Qty	Loc Code
FP001	300	
66821	300	
ST060	636	
72229	136	
76277 ✓	500	

D3791-1 Manufactured No

230 Each

6.0000 1 1

\*D3791-1\*

Wearplate

\*\*

Location	Loc Qty	Loc Code
FP002	6	
62239	2	
75041	4	

D3793-1 Manufactured No

230 Each

19.0000 1 1

\*D3793-1\*

Wearshoe

\*\*

Location	Loc Qty	Loc Code
FP001	19	
77029	7	
78901	12	

D3793-3 Manufactured No

230 Each

14.0000 1 1

\*D3793-3\*

Wearshoe

\*\*

Location	Loc Qty	Loc Code
FP002	14	
78935	14	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 80181

**\*80181\***

Parent Item: D350-636-014

**\*D350-636-014\***

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230 Each

12.0000

1 1

**\*D3794-1\***

Gasket

\*\*

1 (DP) 12/04/19

Location

Loc Qty

Loc Code

FP002

12

75042 ✓

12

D3794-3

Manufactured No

230 Each

7.0000

1 1

**\*D3794-3\***

Gasket

\*\*

1 (DP) 12/04/19

Location

Loc Qty

Loc Code

FP002

7

74530

2

78895

5

MS21043-6

Purchased No

230 Each

817.0000

4 4

**\*MS21043-6\***

NUT

\*\*

4 (DP) 12/04/19

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

797

112314

87

117887

10

118384 ✓

200

120308

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 80181

\*80181\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

48.0000

1

1

\*MS21083C8\*

NUT

\*\*

1

28

12/04/19

Location

Loc Qty

Loc Code

FP002

120731

1

115884

1

ST303

15

115884

0

118077

1

119309

2

119436

10

119638

2

ST304

32

120142

32

NAS1149C0832R

Purchased

No

230

Each

305.0000

1

1

\*NAS1149C0832R\*

WASHER

\*\*

1

28

12/04/19

Location

Loc Qty

Loc Code

ST297

305

114915 ✓

305

NAS1515H3L

Purchased

No

230

Each

220.0000

4

4

\*NAS1515H3I \*

WASHER

\*\*

4

28

12/04/19

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

180

118686

3

119438

1

120072

76

120360 ✓

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 80181

\*80181\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-005

Purchased

No

230

Each

204.0000

8

8

\*NAS1611-005\*

O-RING

\*\*

8

20

12/01/19

Location

Loc Qty

Loc Code

FP001

204

106099 ✓

31

114220

105

119438

68

NAS1611-010

Purchased

No

230

Each

117.0000

8

8

\*NAS1611-010\*

O-RING

\*\*

8

20

12/04/19

Location

Loc Qty

Loc Code

FP001

117

110915

14

117460

8

118077

1

118612

3

119438

47

120308

44

AN8C21A

Purchased

No

250

Each

53.0000

2

2

\*AN8C21A\*

BOLT

\*\*

2

13

12/04/20

Location

Loc Qty

Loc Code

ST343

53

118758

5

120094

48

120094

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 80181

\*80181\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250 Each

2.0000

1 1

\*D2741\*

Blade, 350 Skidtube

\*\*

76984 JB

Location

Loc Qty

Loc Code

ST

-10

ST466

12

71856

2

D3493-1

Manufactured No

250 Each

32.0000

2 2

\*D3493-1\*

Washer

\*\*

78835 JB

Location

Loc Qty

Loc Code

ST050

32

70697

2

77573

30

MS21083C8

Purchased No

250 Each

48.0000

2 2

\*MS21083C8\*

NUT

\*\*

124019 JB 12/04/20

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

15

115884

0

118077

1

119309

2

119436

10

119638

2

ST304

32

120142

32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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February-13-12 10:41:58 AM

Work Order ID: 80181

\*80181\*

Parent Item: D350-636-014

\*D350-636-014\*

Parent Item Name: Skidtube RH

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Purchased

No

250

Each

237.0000

2

2

\*\*

\*NAS1149D0863.I\*

WASHER

Location

Loc Qty

Loc Code

ST298

237

118078

37

119307

100

120308

100

119307

JB 12/04/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8

7

6

5

4

3

2

1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

## GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

801-81-4.5  
12/02/13

RELEASED  
8-27-13

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL.). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT		
DRAWN	PORT		
CHECKED	PORT		
MFG. APPR.	PORT		
APPROVED	PORT		
DE APPR.	PORT		
DATE	08.07.16		
DART AEROSPACE USA, INC.			
PORT HADLOCK, WA			
DRAWING NO.		REV. F	
D2750		SHEET 1 OF 11	
TITLE		SCALE	
350 SKIDTUBE ASSEMBLY		NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

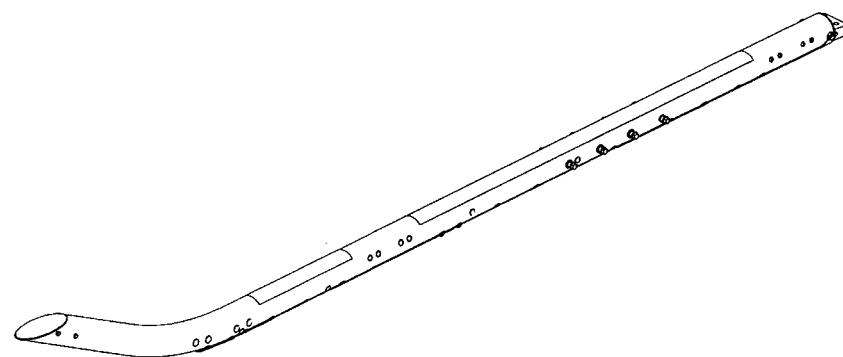
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

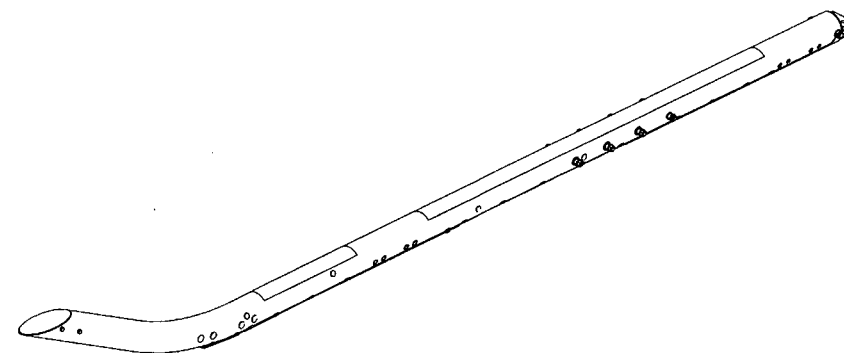
**NOTE:** Date & initial all entries



80181



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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08-09-22-1117

DESIGN	PCY	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PM	PORT HADLOCK, WA	
CHECKED	SA	DRAWING NO.	REV. F
MFG. APPR.	MA	D2750	SHEET 2 OF 11
APPROVED	MA	TITLE	SCALE
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

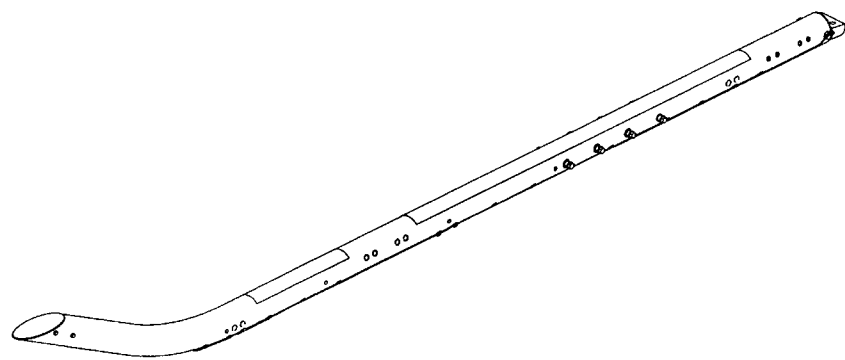
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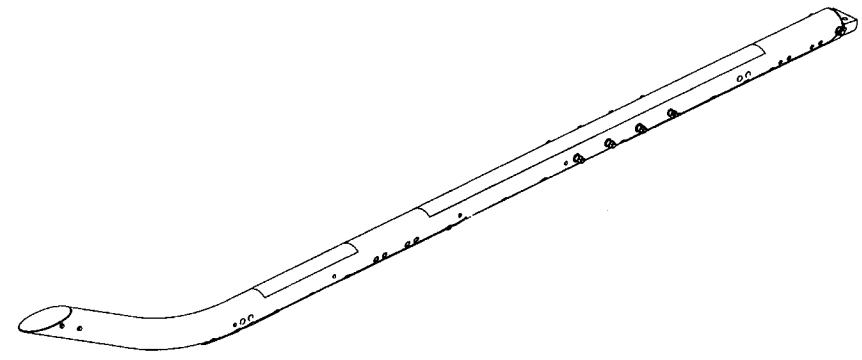
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

80181



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
68-9-22/100

DESIGN	PD	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	NA	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	NA	TITLE	SCALE
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

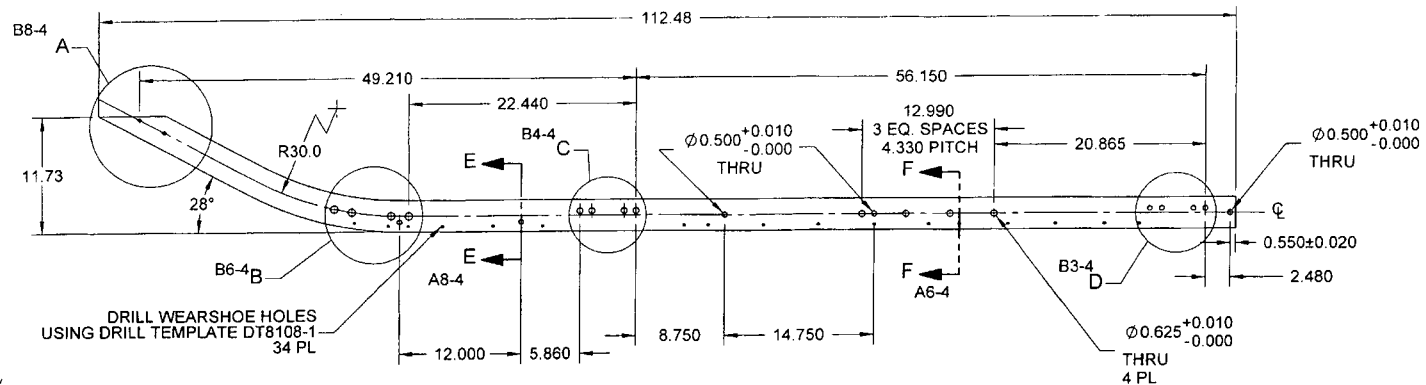
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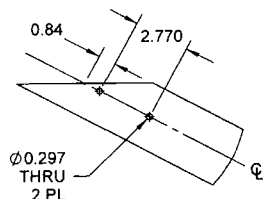
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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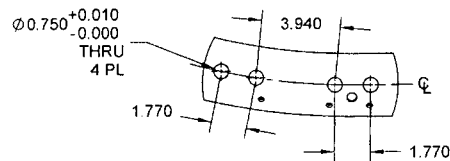
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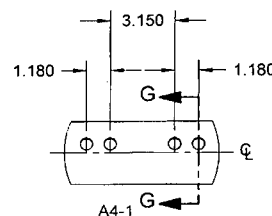
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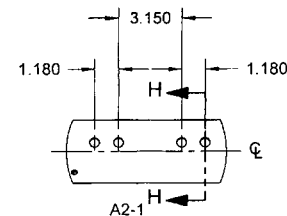
**DETAIL A**  
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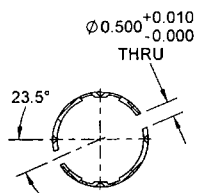
**DETAIL B**  
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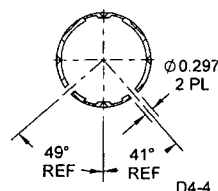
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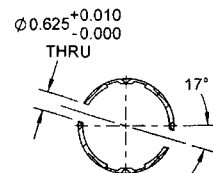
**DETAIL D**  
SCALE 2X



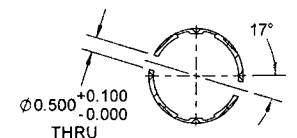
**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION F-F**  
SCALE 3X, 17 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

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DESIGN	IPM	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	IPM	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

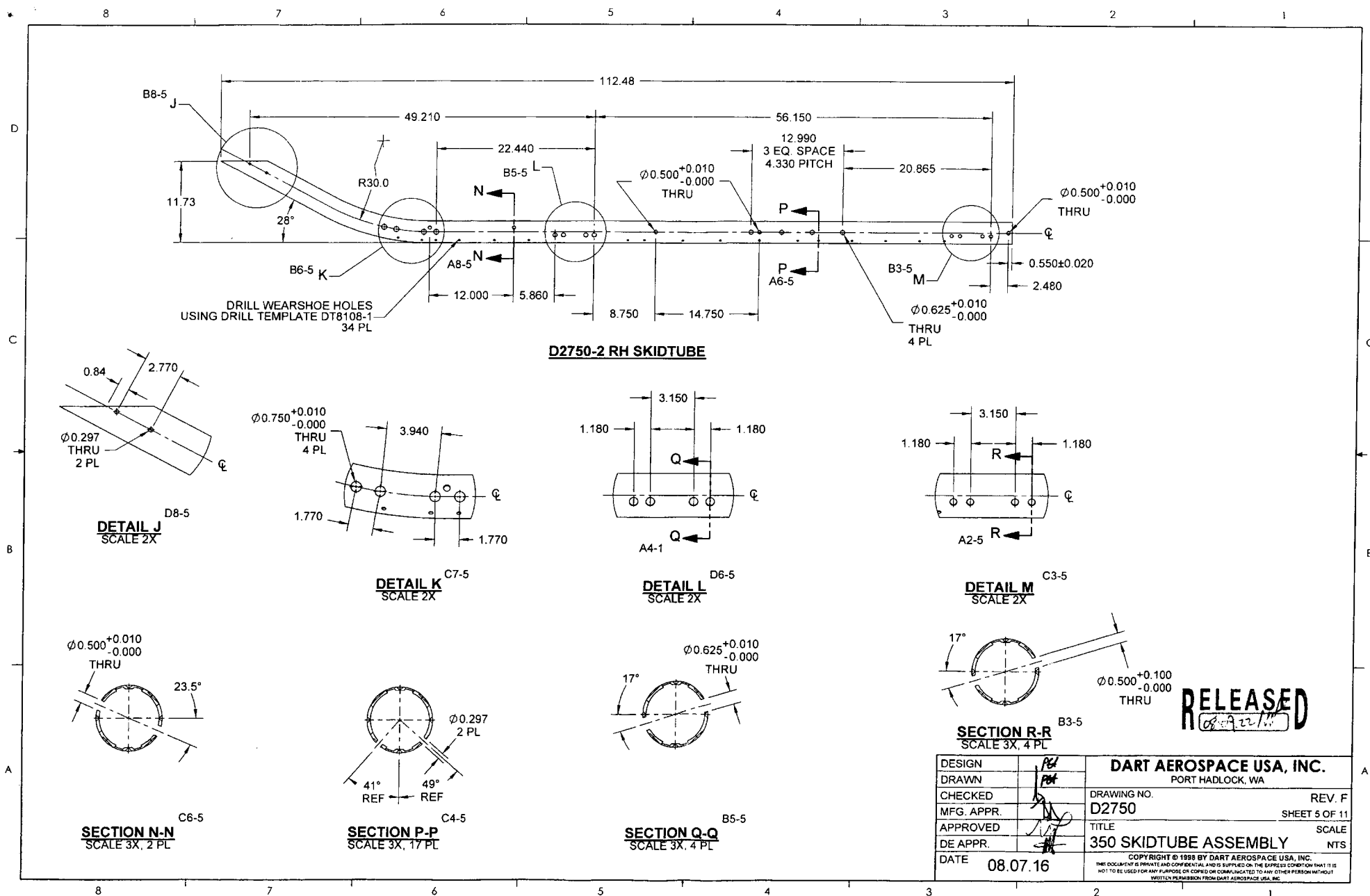
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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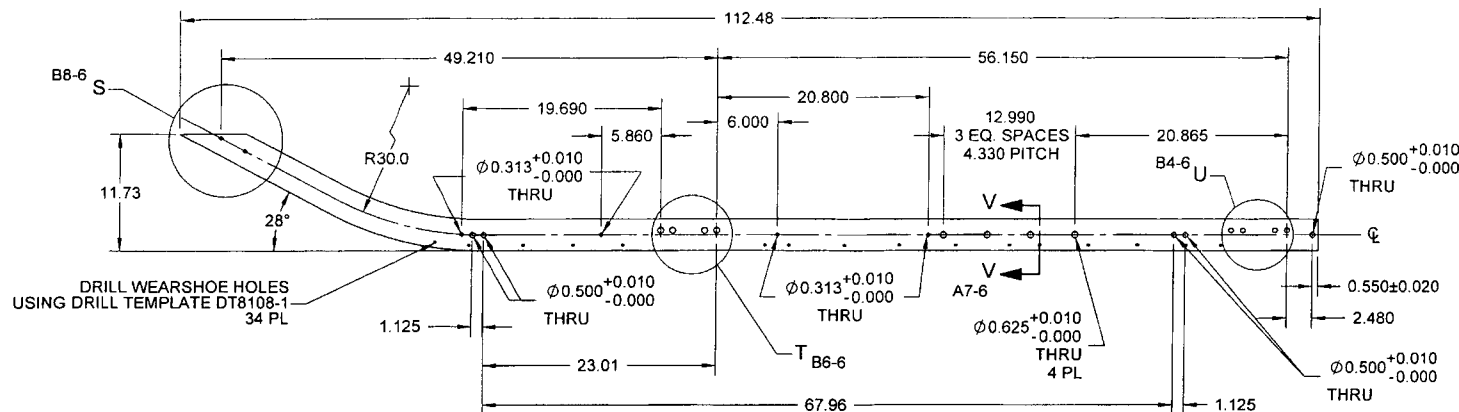
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

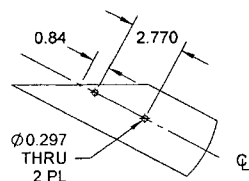


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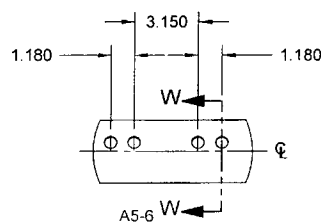
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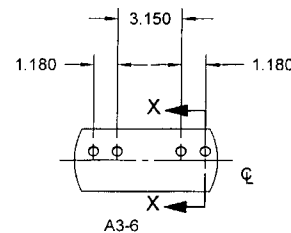
**D2750-3 LH SKIDTUBE**



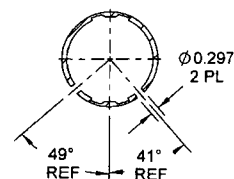
**DETAIL S**  
D8-6  
SCALE 2X



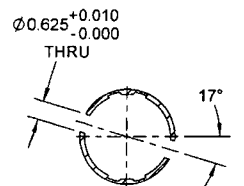
**DETAIL T**  
C5-6  
SCALE 2X



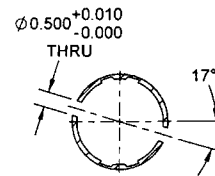
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL



**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL



**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL

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DESIGN		<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.		<b>D2750</b>	SHEET 6 OF 11
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8 7 6 5 4 3 2 1

**Dart Aerospace Ltd**

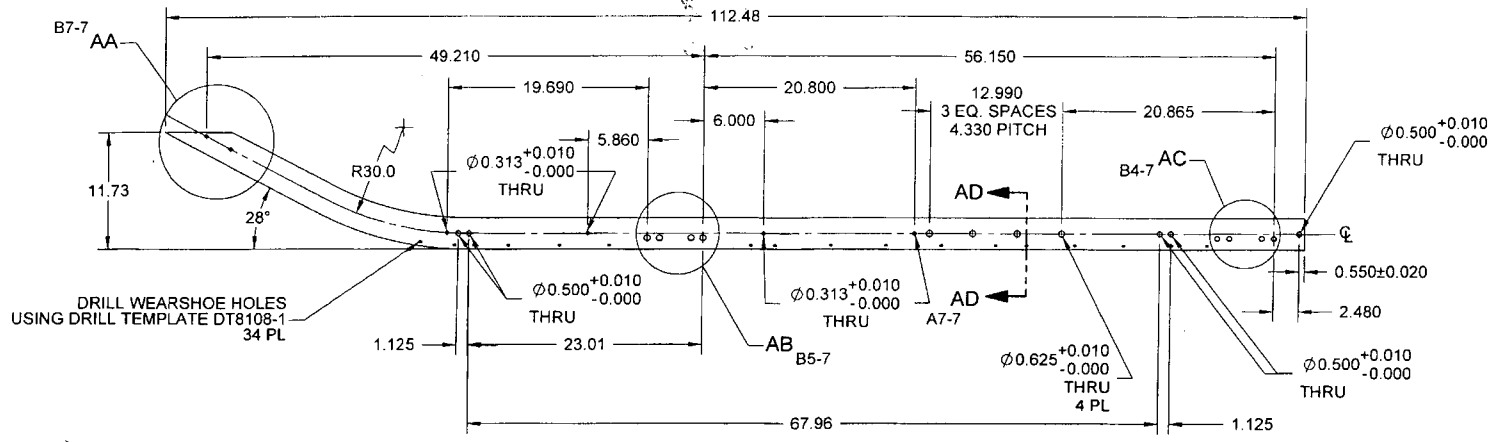
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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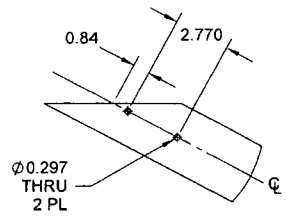
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

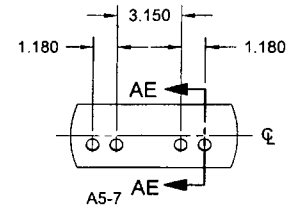
80181



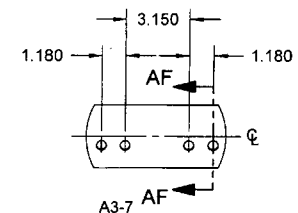
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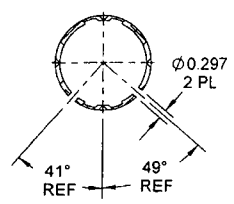
**DETAIL AA**  
SCALE 2X  
D7-7



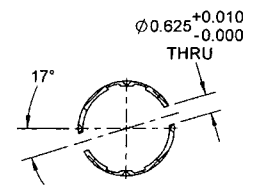
**DETAIL AB**  
SCALE 2X  
C4-7  
A5-7



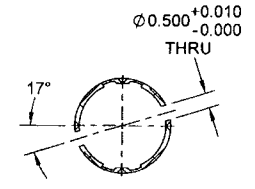
**DETAIL AC**  
SCALE 2X  
D3-7  
A3-7



**SECTION AD-AE**  
SCALE 3X, 17 PL  
D3-7



**SECTION AE-AE**  
SCALE 3X, 4 PL  
B6-7



**SECTION AF-AF**  
SCALE 3X, 4 PL  
B4-7

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06-09-22

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.		<b>D2750</b>	SHEET 7 OF 11
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

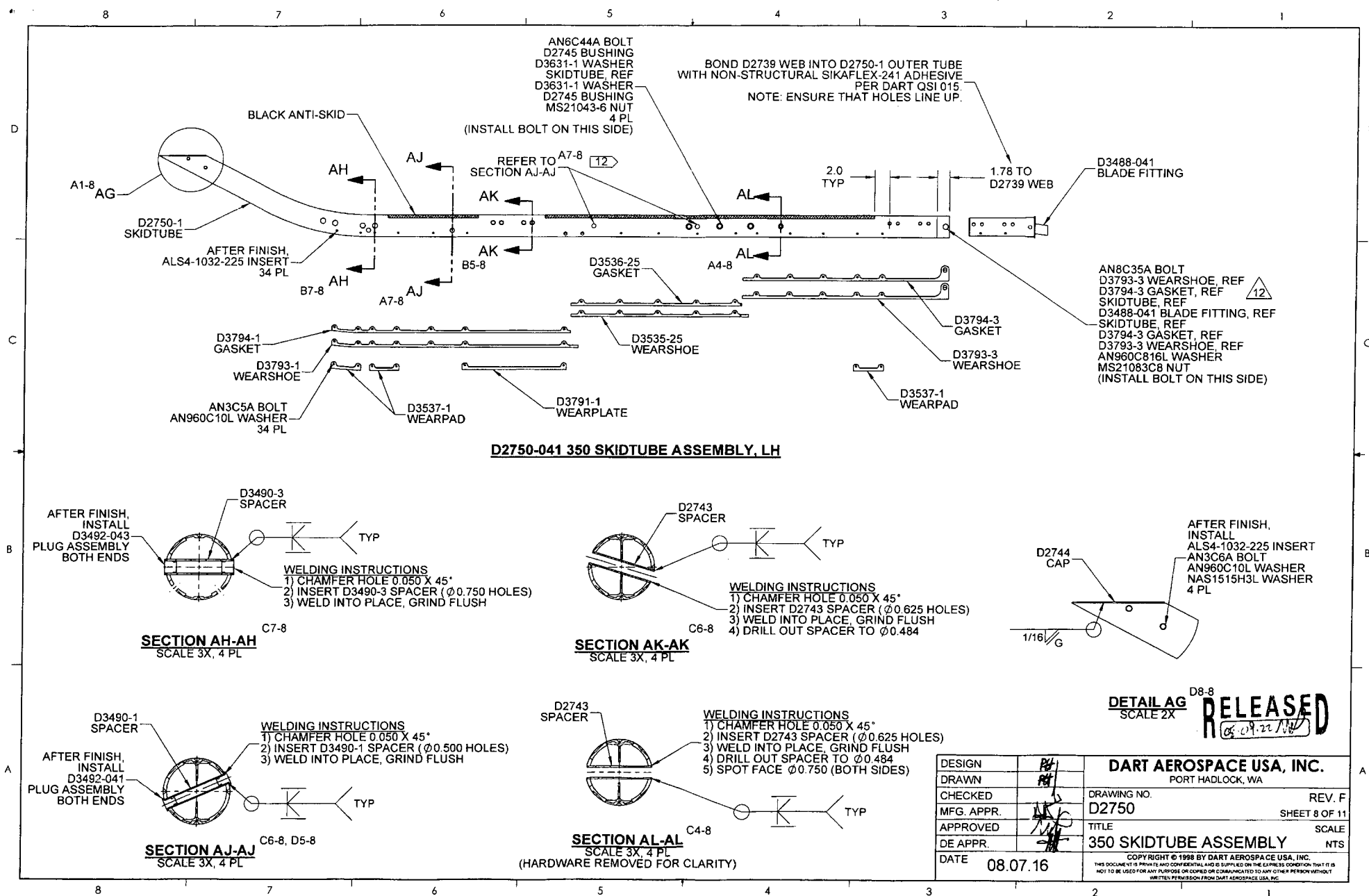
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W/O:		WORK ORDER CHANGES					
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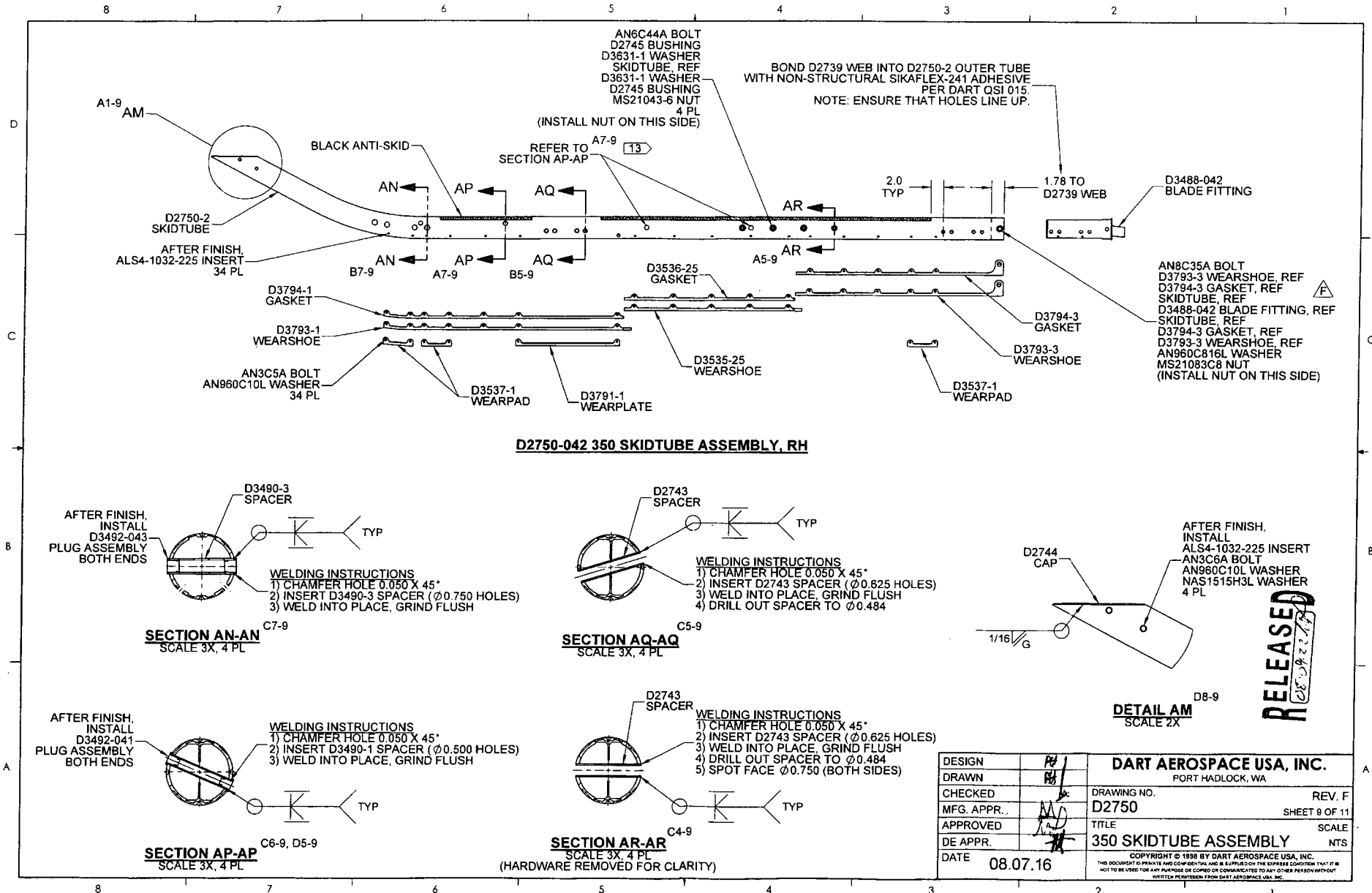
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**NOTE:** Date & initial all entries

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DESIGN	PH	<b>DART AEROSPACE USA, INC.</b>	
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CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	PH	D2750	SHEET 9 OF 11
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	350 SKIDTUBE ASSEMBLY	NTS
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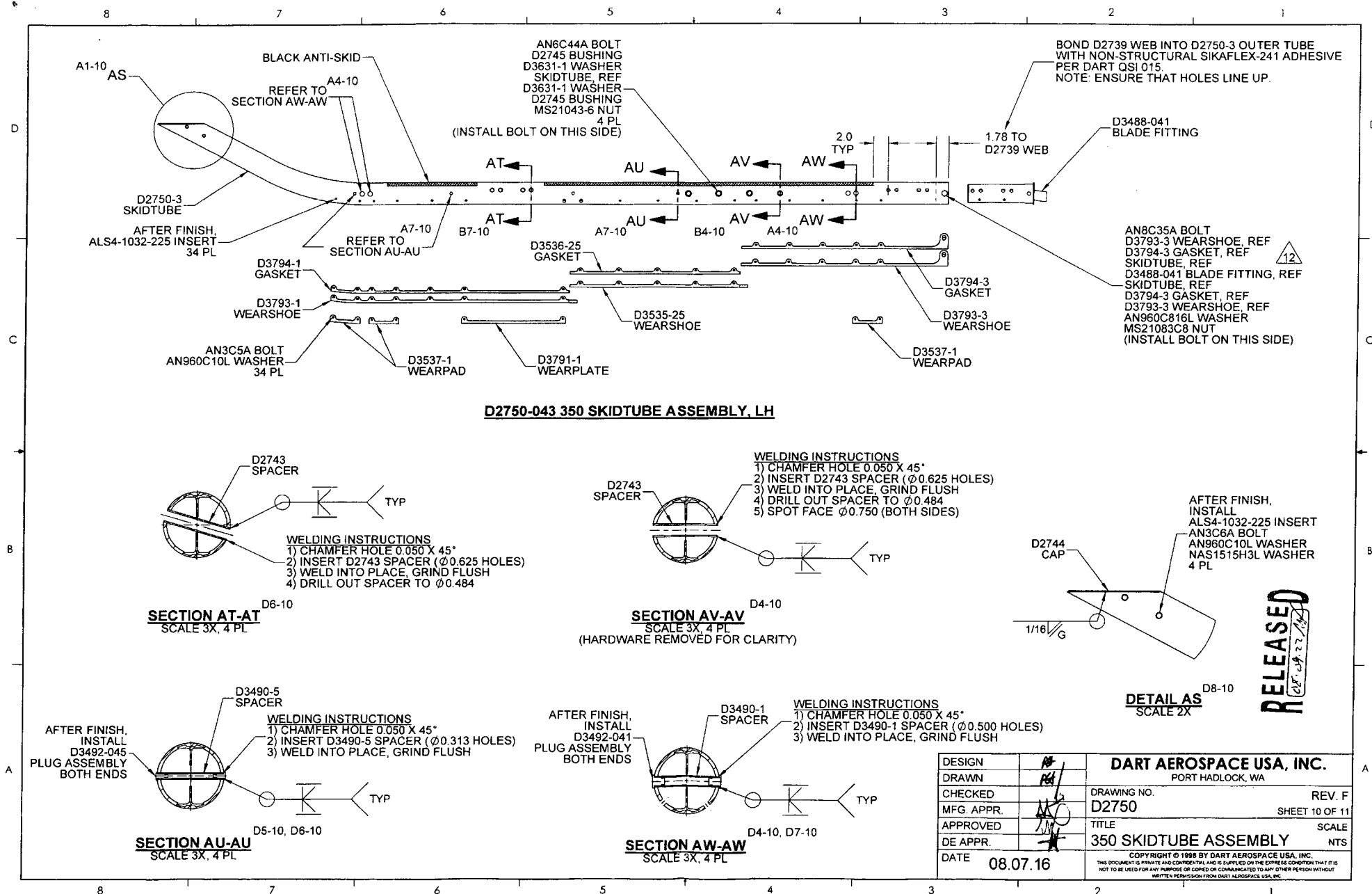
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W/O:		WORK ORDER CHANGES					
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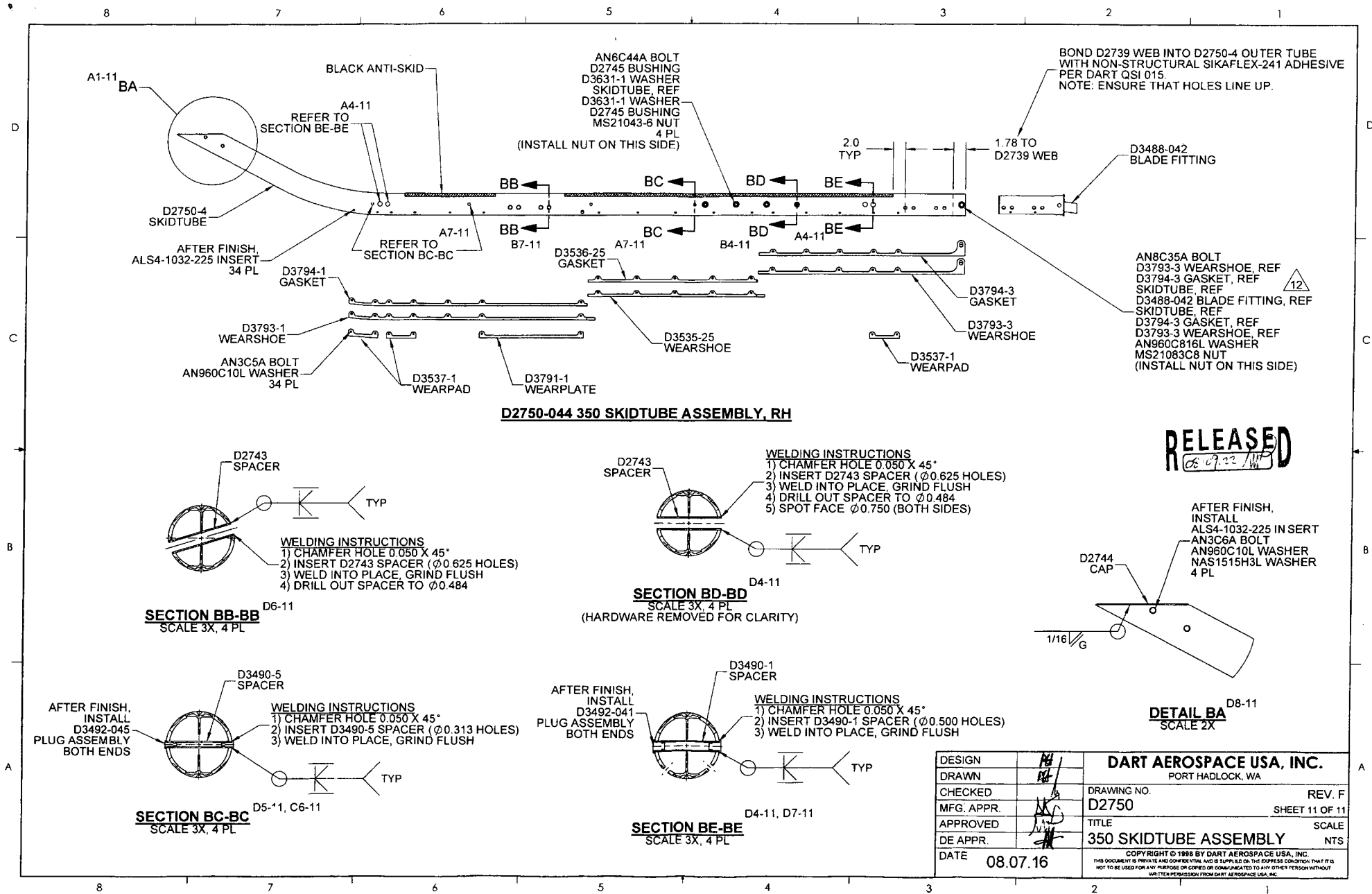
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

80181



DESIGN	MB	<b>DART AEROSPACE USA, INC.</b>
DRAWN	MB	PORT HADLOCK, WA
CHECKED	MB	DRAWING NO. <b>D2750</b>
MFG. APPR.	MB	REV. F
APPROVED	MB	SHEET 11 OF 11
DE APPR.	MB	TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DATE	08.07.16	SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 289

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 81400  
Part number: 1350-636-016  
Description: Shed tube  
Welding Process: Tig ☒ Mig ☐  
Base material: Alum  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:

pass ☒ fail ☐

Penetration:

pass ☒ fail ☐

UNACCEPTABLE

Cracks:

pass ☒ fail ☐

Undercut:

pass ☒ fail ☐

Pin holes:

pass ☒ fail ☐

Overlap (cold lap)

pass ☒ fail ☐

Porosity (surface):

pass ☒ fail ☐

Coloration:

pass ☒ fail ☐

Qualifier David Sewel

Date of Test Coupon 12.04.17

Welder Barclay Elliott

Date of Test Coupon 12.04.17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld